

5145

SPLIT 2433

24433

<b>DART AEROSPACE LTD.</b>	<b>Work Order:</b>	24433
<b>Description:</b> Saddle Fitting, Fwd (Outboard/Inboard)	<b>Part Number:</b>	D2571/D2572
<b>Drawing:</b> D2571 Rev. D/D2572 Rev. D	<b>Qty:</b>	8
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	JH	05.10.12	8
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: 324893	SG	05/12/13	8
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: 321817-A	SG	05/12/13	8
4	MV	Fixturing W/O No. Fixturing Inspection last completed by		N/A	
5	MV	Program Batch No. 24433 Double check by: E	JL	05.12.28	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	MS	06/01/09	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	MS	06/01/09	8
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	MS	06/01/09	8
9	MV	Machine keyway as per dwg D2571 & D2572	MS	06/01/09	8
10	MV	Deburr and remove all machining marks	MS	06/01/09	8
11	MV	Tumble for 20 minutes to remove sharp edges # 04.06.21 N/A	MS	06/01/09	8
12	QC1	Inspect all dimensions to dimension sheets	MS	06/01/09	8
13	QC7	Second inspection	ML	06/01/09	2
14	FP	Acid etch and alodine as per QSI 005 4.1	ML	06 01 09	2
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	ML	06 01 10	2
16	QC3	Inspect Powder Coat	CL	06/01/10	2
17	ST	Identify and Stock.	CL	06/01/10	2
18	AC	Cost / Part	SA	06-01-11	2
19	DC	Close W/O Inspection Level 21	PD	06/01/11	2

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED

02/10/15 RF





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24433
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.749	1.750	1.752		
C	3.495	3.505		3.500	3.500	3.501	3.504		
D	1.745	1.755		1.750	1.749	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.010	8.000		
F	0.490	0.510		.501	.500	.507	.500		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.500	.499	.498	.497		
J	1.174	1.184		1.180	1.179	1.179	1.180		
K	0.558	0.578		.568	.566	.565	.568		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.490	1.500		1.495	1.495	1.494	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.875	3.872		
P	0.115	0.135		.128	.128	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.254	.253	.249	.255		
S	0.115	0.135		.126	.128	.130	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.961	2.962	2.962		
V	0.230	0.250		.240	.241	.247	.248		
W	0.115	0.135		.118	.125	.125	.127		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.365	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.629	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	.250	.260	.252		
AE	1.375	1.395		1.387	1.388	1.386	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.255	.252	.254	.245		
AI	2.000	2.020		2.001	2.002	2.002	2.001		
Accept/Reject									

AS 0.023 / 0.043

1.030

.030

Measured by:	J.L
Date:	05.12.28

Audited by:	<i>[Signature]</i>
Date:	06/01/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	<i>[Signature]</i>

RELEASED  
20.05.05





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 24433
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.751	1.751	1.752	1.751		
C	3.495	3.505		3.500	3.501	3.500	3.501		
D	1.745	1.755		1.751	1.751	1.751	1.751		
E	7.990	8.010		8.002	8.001	8.002	8.004		
F	0.490	0.510		.499	.498	.499	.499		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.504	.503	.500	.500		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.565	.569	.572	.572		
L	1.174	1.184		1.180	1.180	1.179	1.180		
M	1.490	1.500		1.496	1.493	1.494	1.494		
N	2.495	2.505		2.501	2.500	2.500	2.499		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		.127	.128	.128	.129		
Q	0.115	0.135		.128	.135	.132	.130		
R	0.240	0.260		.249	.248	.255	.257		
S	0.115	0.135		.129	.127	.128	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.964	2.962		
V	0.230	0.250		.241	.244	.244	.245		
W	0.115	0.135		.128	.130	.130	.127		
X	0.308	0.313							
Y	0.760	0.765							
Z	0.352	0.372		.362	.362	.362	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.250	.250	.250		
AE	1.375	1.395		1.383	1.384	1.384	1.385		
AF	0.115	0.135		.134	.135	.135	.130		
AG	0.240	0.280		.270	.269	.258	.242		
AH	0.240	0.260		.249	.250	.253	.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject				2.001					

AJ 0.023 0.043

Measured by:	MS
Date:	06/01/03

Audited by:	mf
Date:	06/01/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	7/2

RELEASED  
20.05.05





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24433
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	/	/	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.751		
C	3.495	3.505		3.500	3.500	3.500	3.503		
D	1.745	1.755		1.750	1.749	1.750	1.751		
E	7.990	8.010		8.001	7.998	7.991	8.005		
F	0.490	0.510		.500	.498	.498	.500		
G	0.257	0.262	DT8683	/	/	✓	✓		
H	0.375	0.380	DT8684	/	/	✓	✓		
I	0.490	0.510		.500	.498	.497	.499		
J	1.174	1.184		1.179	1.179	1.181	1.180		
K	0.558	0.578		.568	.565	.569	.568		
L	1.174	1.184		1.180	1.179	1.179	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.501	2.502	2.500		
O	3.869	3.879		3.874	3.874	3.873	3.872		
P	0.115	0.135		.126	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.253	.250	.256		
S	0.115	0.135		.124	.124	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.962	2.964		
V	0.230	0.250		.240	.237	.241	.239		
W	0.115	0.135		.130	.127	.131	.129		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.762		
Z	0.352	0.372		.358	.361	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.628	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.250	.251		
AE	1.375	1.395		1.388	1.388	1.387	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.265	.248	.245		
AH	0.240	0.260		.247	.251	.249	.254		
AI	2.000	2.020			Can	measure			
Accept/Reject						2.005	2.000		

AJ

Measured by:	JL
Date:	05.12.28

Audited by:	mx
Date:	06/01/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	

RELEASED  
05.05.05





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 24433
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.751	1.752	1.751	1.752		
C	3.495	3.505		3.502	3.502	3.500	3.502		
D	1.745	1.755		1.751	1.751	1.751	1.750		
E	7.990	8.010		8.000	8.001	8.002	8.005		
F	0.490	0.510		.505	.506	.500	.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.503	.500	.500	.500		
J	1.174	1.184		1.178	1.178	1.180	1.179		
K	0.558	0.578		.572	.571	.572	.572		
L	1.174	1.184		1.178	1.178	1.180	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.871	3.870	3.870	3.870		
P	0.115	0.135		.128	.127	.128	.128		
Q	0.115	0.135		.134	.135	.135	.135		
R	0.240	0.260		.254	.254	.255	.251		
S	0.115	0.135		.125	.125	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.962	2.965		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.126	.125	.127	.127		
X	0.307	0.312							
Y	0.760	0.765							
Z	0.352	0.372		.363	.363	.363	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635							
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.249	.255	.256		
AE	1.375	1.395		1.388	1.388	1.387	1.388		
AF	0.115	0.135		.132	.129	.129	.129		
AG	0.240	0.280		.248	.245	.247	.246		
AH	0.240	0.260		.251	.250	.250	.250		
AI	2.000	2.020		2.002	2.001	2.000	2.001		
Accept/Reject									

Measured by:	M8
Date:	06/01/03

Audited by:	FWL
Date:	06/01/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	

RELEASED  
05.05.05

